

SECTION 03300 - CAST-IN-PLACE STRUCTURAL CONCRETE

City of San Diego, CWP Guidelines

PART 1 -- GENERAL

1.1 WORK OF THIS SECTION

- A. The WORK of this Section includes providing finished cast-in-place structural concrete including forming, mixing, placing, curing, repairing, and finishing.
- B. The following types of concrete shall be covered in this Section:
 - 1. Structural Concrete: Concrete to be used in all cases except where indicated otherwise.
 - 2. Lean Concrete: Concrete to be used for thrust blocks, pipe trench cut-off blocks and cradles, where the preceding items are indicated as unreinforced. Lean concrete shall be used as protective cover for dowels intended for future connection.
- C. The term "hydraulic structure" used in these specifications shall refer to environmental engineering concrete structures for the containment, treatment, or transmission of water, wastewater, or other fluids.

1.2 RELATED SECTIONS

- A. The WORK of the following Sections applies to the WORK of this Section. Other Sections of the Specifications, not referenced below, shall also apply to the extent required for proper performance of this WORK.
 - 1. Section 03100 Concrete Formwork
 - 2. Section 03200 Reinforcement Steel
 - 3. Section 03240 Prestressed Circular Tanks (Wire Wrap System)
 - 4. Section 03280 Joints in Sitework Concrete
 - 5. Section 03290 Joints in Concrete Structures
 - 6. Section 03400 Precast Concrete Panels
 - 7. Section 03315 Grout
 - 8. Section 03520 Lightweight Insulating Concrete Deck
 - 9. Section 07920 Sealants and Caulking

1.3 SPECIFICATIONS AND STANDARDS

- A. Except as otherwise indicated, the current editions of the following apply to the WORK of this Section.
- B. **Federal Specifications:**
 - UU-B-790A (Int.Amd. 1) Building Paper, Vegetable Fiber (Kraft, Waterproofed, Water Repellant and Fire Resistant).
- C. **Commercial Standards:**
 - ACI 117 Standard Tolerances for Concrete Construction and Materials

ACI 214	Recommended Practice for Evaluation of Strength Test Results of Concrete
ACI 301	Specifications for Structural Concrete for Buildings
ACI 309	Consolidation of Concrete
ACI 315	Details and Detailing of Concrete Reinforcement
ACI 318	Building Code Requirements for Structural Concrete
ASTM C 31	Practices for Making and Curing Concrete Test Specimens in the Field
ASTM C 33	Specification for Concrete Aggregates
ASTM C 39	Test Method for Compressive Strength of Cylindrical Concrete Specimens
ASTM C 40	Test Method for Organic Impurities in Fine Aggregates for Concrete
ASTM C 88	Test Method for Soundness of Aggregates by Use of Sodium Sulfate or Magnesium Sulfate
ASTM C 94	Specification for Ready-Mixed Concrete
ASTM C 131	Test Method for Resistance to Degradation of Small-Size Coarse Aggregate by Abrasion and Impact in the Los Angeles Machine
ASTM C 143	Test Method for Slump of Portland Cement Concrete
ASTM C 150	Specification for Portland Cement
ASTM C 157	Test Method for Length Change of Hardened Hydraulic Cement Mortar and Concrete
ASTM C 172	Standard Method of Sampling Freshly Mixed Concrete
ASTM C 192	Method of Making and Curing Concrete Test Specimens in the Laboratory
ASTM C 260	Specification for Air-Entraining Admixtures for Concrete
ASTM C 289	Test Method for Potential Reactivity of Aggregates (Chemical Method)
ASTM C 309	Specifications for Liquid Membrane-Forming Compounds for Curing Concrete
ASTM C 494	Specification for Chemical Admixtures for Concrete

ASTM C 535	Test Method for Resistance to Degradation of Large-Size Coarse Aggregate by Abrasion and Impact in the Los Angeles Machine
ASTM C 1077	Standard Practice for Laboratories Testing Concrete and Concrete Aggregates for use in Construction & Criteria for Laboratory Evaluation
ASTM D 175	Specification for Preformed Expansion Joint Fillers for Concrete Paving and Structural Construction (Non-extruding and Resilient Bituminous Types)
ASTM D 2419	Test Method for Sand Equivalent Value of Soils and Fine Aggregate
ASTM E 119	Method for Fire Tests of Building Construction and Materials

1.4 SHOP DRAWINGS AND SAMPLES

A. The following shall be submitted in compliance with Section 01300

1. **Mix Designs:** Prior to beginning the WORK and within 14 days of the notice to proceed, preliminary concrete mix designs which shall show the proportions and gradations of all materials proposed for each class and type of concrete. The mix designs shall be checked by an independent testing laboratory acceptable to the CONSTRUCTION MANAGER. All costs related to such checking shall be borne by the CONTRACTOR.
2. Provide the following submittals in accordance with ACI-301:
 - a. Mill tests for cement.
 - b. Admixture certification. Chloride ion content must be included.
 - c. Aggregate gradation and certification.
 - d. Materials and methods for curing.
3. **Certified Delivery Tickets:** Where ready-mix concrete is used, the CONTRACTOR shall provide certified weighmaster delivery tickets at the time of delivery of each load of concrete. CONTRACTOR'S certificate with each delivery ticket shall show the public weighmaster's signature, and the total quantities, by weight of cement, sand, each class of aggregate, admixtures, and the amounts of water in the aggregate and added at the batching plant as well as the amount of water allowed to be added at the site for the specific design mix. Each certificate shall, in addition, state the mix number, total yield in cubic yards, and the time of day, to the nearest minute, corresponding to when the batch was dispatched, when it left the plant, when it arrived at the job, the time that unloading began, and the time that unloading was finished.

1.5 CONCRETE CONFERENCE

- A. A meeting to review the detailed requirements of the CONTRACTOR's proposed concrete design mixes and to determine the procedures for producing proper concrete construction shall be held no later than 14 days after the notice to proceed.
- B. All parties involved in the concrete work shall attend the conference, including the following:
 - CONTRACTOR's representative
 - Testing laboratory representative
 - Concrete subcontractor
 - Reinforcing steel subcontractor and detailer
 - Concrete supplier
 - Admixture manufacturer's representative
- C. The conference shall be held at a mutually agreed upon time and place. The CONSTRUCTION MANAGER shall be notified no less than 5 days prior to the date of the conference.

1.6 TESTING

A. General

- 1. Tests on component materials and for compressive strength and shrinkage of concrete will be performed as specified herein. Test for determining slump will be in accordance with the requirements of ASTM C 143.
- 2. The cost of all laboratory tests on cement, aggregates, and concrete, will be borne by the OWNER. However, the CONTRACTOR shall be charged for the cost of any additional tests and investigation on work performed which does not meet the specifications. The laboratory must meet or exceed the requirements of ASTM C 1077.
- 3. Concrete for testing shall be supplied by the CONTRACTOR at no cost to the OWNER, and the CONTRACTOR shall provide assistance to the CONSTRUCTION MANAGER in obtaining samples, and disposal and cleanup of excess material.

B. Field Compression Tests:

- 1. Compression test specimens will be taken during construction from the first placement of each class of concrete specified herein and at intervals thereafter as selected by the CONSTRUCTION MANAGER to insure continued compliance with these specifications. Each set of test specimens will be a minimum of 4 cylinders.
- 2. Compression test specimens for concrete will be made and cured in accordance with ASTM C 31. Specimens will be 6-inch diameter by 12-inch high cylinders.
- 3. Compression tests will be performed in accordance with ASTM C 39. One test cylinder will be tested at 7 days and 2 at 28 days. The remaining cylinder will be held to verify test results, if needed.

C. Evaluation and Acceptance of Concrete:

- 1. Evaluation and acceptance of the compressive strength of concrete shall be according to the requirements of ACI 318, Chapter 5 "Concrete Quality," and as specified herein.

2. A statistical analysis of compression test results will be performed according to the requirements of ACI 214. The standard deviation of the test results shall not exceed 640 psi.
3. If any concrete fails to meet these requirements, immediate corrective action shall be taken to increase the compressive strength for all subsequent batches of the type of concrete affected.
4. When the standard deviation of the test results exceeds 640 psi, the average strength for which the mix is designed shall be increased by an amount necessary to satisfy the statistical requirement that the probability of any test being more than 500 psi below or the average of any 3 consecutive tests being below the specified compressive strength is 1 in 100. The required average strength shall be calculated by Criterion No. 3 of ACI 214 using the actual standard of deviation.
5. All concrete which fails to meet the ACI requirements and these specifications, is subject to removal and replacement at no additional cost to the OWNER.

D. Shrinkage Tests:

1. Drying shrinkage tests will be made for the trial batch indicated below, the first placement of each class of concrete, and during construction to insure continued compliance with these Specifications.
2. Drying shrinkage specimens shall be 4-inch by 4-inch by 11-inch prisms with an effective gauge length of 10 inches, fabricated, cured, dried and measured in accordance with ASTM C 157 modified as follows: specimens shall be removed from molds at an age of 23 ± 1 hours after trial batching, shall be placed immediately in water at 70 degrees F ± 3 degrees F for at least 30 minutes, and shall be measured within 30 minutes thereafter to determine original length and then submerged in saturated lime water at 73 degrees F ± 3 degrees F. Measurement to determine expansion expressed as a percentage of original length shall be made at age 7 days. This length at age 7 days shall be the base length for drying shrinkage calculations ("0" days drying age). Specimens then shall be stored immediately in a humidity control room maintained at 73 degrees F ± 3 degrees F and 50 percent ± 4 percent relative humidity for the remainder of the test. Measurements to determine shrinkage expressed as percentage of base length shall be made and reported separately for 7, 14, 21, and 28 days of drying after 7 days of moist curing.
3. The drying shrinkage deformation of each specimen shall be computed as the difference between the base length (at "0" days drying age) and the length after drying at each test age. The average drying shrinkage deformation of the specimens shall be computed to the nearest 0.0001 inch at each test age. If the drying shrinkage of any specimen departs from the average of that test age by more than 0.0004-inch, the results obtained from that specimen shall be disregarded. Results of the shrinkage test shall be reported to the nearest 0.001 percent of shrinkage. Compression test specimens shall be taken in each case from the same concrete used for preparing drying shrinkage specimens. These tests shall be considered a part of the normal compression tests for the project. Allowable shrinkage limitations shall be as indicated below.

- E. Construction Tolerances:** The CONTRACTOR shall set and maintain concrete forms and perform finishing operations so as to ensure that the completed work is within the tolerances specified herein. Surface defects and irregularities are defined as finishes and are to be distinguished from tolerances. Tolerance is the specified permissible variation from lines, grades, or dimensions shown. Where

tolerances are not stated in the specifications, permissible deviations will be in accordance with ACI 117.

1. The following construction tolerances are hereby established and apply to finished walls and slab unless otherwise shown:

Item	Tolerance
Variation of the constructed linear outline from the established position in plan.	In 10 feet: 1/4-inch; In 20 feet or more: 1/2-inch
Variation from the level or from the grades shown.	In 10 feet: 1/4-inch; In 20 feet or more: 1/2-inch
Variation from the plumb	In 10 feet: 1/4-inch; In 20 feet or more: 1/2-inch
Variation in the thickness of slabs and walls.	Minus 1/4-inch; Plus 1/2-inch
Variation in the locations and sizes of slabs and wall openings	Plus or minus 1/4-inch

PART 2 -- PRODUCTS

2.1 CONCRETE MATERIALS

A. General:

1. All materials specified herein shall be classified as acceptable for potable water use by the Environmental Protection Agency within 30 days of application.
 2. Materials shall be delivered, stored, and handled so as to prevent damage by water or breakage. Only one brand of cement shall be used. Cement reclaimed from cleaning bags or leaking containers shall not be used. All cement shall be used in the sequence of receipt of shipments.
- B. All materials furnished for the work shall comply with the requirements of Sections 201, 203, and 204 of ACI 301, as applicable.
- C. Storage of materials shall conform to the requirements of Section 205 of ACI 301.
- D. Materials for concrete shall conform to the following requirements:
1. Cement shall be standard brand portland cement conforming to ASTM C 150 for Type II or Type V, including Table 1A optional requirements. A minimum of 85 percent of cement by weight shall pass a 325 screen. A single brand of cement shall be used throughout the work, and prior to its use, the brand shall be acceptable to the CONSTRUCTION MANAGER. The cement shall be suitably protected from exposure to moisture until used. Cement that has become lumpy shall not be used. Sacked cement shall be stored in such a manner so as to permit access for inspection and sampling. Certified mill test reports, including fineness, for

each shipment of cement to be used shall be submitted to the CONSTRUCTION MANAGER if requested regarding compliance with these Specifications.

2. Water for mixing and curing shall be potable, clean, and free from objectionable quantities of silty organic matter, alkali, salts and other impurities. The water shall be considered potable, for the purposes of this Section only, if it meets the requirements of the local governmental agencies. Agricultural water with high total dissolved solids (over 1000 mg/l TDS) shall not be used.
3. Aggregates shall be obtained from pits acceptable to the CONSTRUCTION MANAGER, shall be non-reactive, and shall conform to ASTM C 33. Maximum size of coarse aggregate shall be as specified herein. Lightweight sand for fine aggregate will not be permitted.
 - a. Coarse aggregates shall consist of clean, hard, durable gravel, crushed gravel, crushed rock or a combination thereof. The coarse aggregates shall be prepared and handled in two or more size groups for combined aggregates with a maximum size greater than 3/4-inch. When the aggregates are proportioned for each batch of concrete the two size groups shall be combined. See the requirements below for the use of the size groups.
 - b. Fine aggregates shall be natural sand or a combination of natural and manufactured sand that are hard and durable. When tested in accordance with ASTM D2419, the sand equivalency shall not be less than 75 percent for an average of three samples, nor less than 70 percent for an individual test. Gradation of fine aggregate shall conform to ASTM C 33, with 15 to 30 percent passing the number 50 screen and 5 to 10 percent passing the number 100 screen. The fineness modulus of sand used shall not be over 3.00.
 - c. Combined aggregates shall be well graded from coarse to fine sizes, and shall be uniformly graded between screen sizes to produce a concrete that has optimum workability and consolidation characteristics. Where a trial batch is required for a mix design, the final combined aggregate gradations will be established during the trial batch process.
 - d. When tested in accordance with ASTM C 289, the ratio of silica released to reduction in alkalinity shall not exceed 1.0.
 - e. When tested in accordance with ASTM C 40, the fine aggregate shall produce a color in the supernatant liquid no darker than the reference standard color solution.
 - f. When tested in accordance with ASTM C 131 or ASTM C 535, the coarse aggregate shall show a loss not exceeding 42 percent after 500 revolutions, or 10.5 percent after 100 revolutions.
 - g. When tested in accordance with ASTM C 88, the loss resulting after five cycles shall not exceed 10 percent for fine or coarse aggregate when using sodium sulfate.
4. Ready-mix concrete shall conform to the requirements of ASTM C 94.
5. Admixtures: All admixtures shall be compatible and by a single manufacturer capable of providing qualified field service representation. Admixtures shall be used in accordance with manufacturer's recommendations. If the use of an admixture is producing an inferior end result, the CONTRACTOR shall discontinue use of the admixture. Admixtures shall not

contain thiocyanates nor more than 0.05 percent chloride ion, and shall be non-toxic after 30 days.

- a. Air-entraining agent meeting the requirements of ASTM C 260 shall be used. Sufficient air-entraining agent shall be used to provide a total air content of 3 to 5 percent. The OWNER reserves the right, at any time, to sample and test the air-entraining agent received on the job by the CONTRACTOR. The air-entraining agent shall be added to the batch in a portion of the mixing water. The solution shall be batched by means of a mechanical batcher capable of accurate measurement. Air content shall be tested at the point of placement.
- b. Set controlling and water reducing admixtures: Admixtures may be added at the CONTRACTOR's option to control the set, effect water reduction, and increase workability. The addition of an admixture shall be at the CONTRACTOR's expense. The use of an admixture shall be subject to acceptance by the CONSTRUCTION MANAGER. Concrete containing an admixture shall be first placed at a location determined by the CONSTRUCTION MANAGER. Admixtures specified herein shall conform to the requirements of ASTM C 494. The required quantity of cement shall be used in the mix regardless of whether or not an admixture is used.
 - (1) Concrete shall not contain more than one water reducing admixture. Concrete containing an admixture shall be first placed at a location determined by the CONSTRUCTION MANAGER.
 - (2) Set controlling admixture shall be either with or without water-reducing properties. Where the air temperature at the time of placement is expected to be consistently over 80 degrees F, a set retarding admixture shall be used.
 - (3) Normal range water reducer shall conform to ASTM C 494, Type A. The quantity of admixture used and the method of mixing shall be in accordance with the Manufacturer's instructions and recommendations.
 - (4) High range water reducer shall conform to ASTM C 494, Type F or G. High range water reducer shall be added to the concrete after all other ingredients have been mixed and initial slump has been verified. No more than 14 ounces of water reducer per sack of cement shall be used. Water reducer shall be considered as part of the mixing water when calculating water cement ratio.
 - (5) If the high range water reducer is added to the concrete at the job site, it may be used in conjunction with the same water reducer added at the batch plant. Concrete shall have a slump of 3 inches \pm 1/2-inch prior to adding the high range water reducing admixture at the job site. The high range water reducing admixture shall be accurately measured and pressure injected into the mixer as a single dose by an experienced technician. A standby system shall be provided and tested prior to each day's operation of the job site system.
 - (6) Concrete shall be mixed at mixing speed for a minimum of 30 mixer revolutions after the addition of the high range water reducer.
 - (7) Flyash shall not be used.

2.2 CURING MATERIALS

A. Materials for curing concrete as specified herein shall conform to the following requirements and ASTM C 309:

1. All curing compounds shall be white pigmented, resin based; Sodium silicate compounds shall not be allowed. Only water based resin curing compounds shall be used.
2. Polyethylene sheet for use as concrete curing blanket shall be white, and shall have a nominal thickness of 6 mils. The loss of moisture when determined in accordance with the requirements of ASTM C 156 shall not exceed 0.055 grams per square centimeter of surface.
3. Polyethylene-coated waterproof paper sheeting for use as concrete curing blanket shall consist of white polyethylene sheeting free of visible defects, uniform in appearance, having a nominal thickness of 2 mils and permanently bonded to waterproof paper conforming to the requirements of Federal Specification UU-B-790A (Int. Amd. 1). The loss of moisture, when determined in accordance with the requirements of ASTM C 156, shall not exceed 0.055 gram per square centimeter of surface.
4. Polyethylene-coated burlap for use as concrete curing blanket shall be 4-mil thick, white opaque polyethylene film impregnated or extruded into one side of the burlap. Burlap shall weigh not less than 9 ounces per square yard. The loss of moisture, when determined in accordance with the requirements of ASTM C 156, shall not exceed 0.055 grams per square centimeter of surface.
5. Curing mats for use in Curing Method 6 as specified herein, shall be heavy shag rugs or carpets or cotton mats quilted at 4 inches on center. Curing mats shall weigh a minimum of 12 ounces per square yard when dry.

2.3 NON-WATERSTOP JOINT MATERIALS

A. Materials for non-waterstop joints in concrete shall conform to the following requirements:

1. Preformed joint filler for non-water retaining applications shall be a non-extruding, resilient, bituminous type conforming to the requirements of ASTM D 1751.
2. Elastomeric joint sealer shall conform to the requirements of Section 07920.
3. Mastic joint sealer shall be a material that does not contain evaporating solvents; that will tenaciously adhere to concrete surfaces; that will remain permanently resilient and pliable; that will not be affected by continuous presence of water and will not in any way contaminate potable water; and that will effectively seal the joints against moisture infiltration even when the joints are subject to movement due to expansion and contraction. The sealer shall be composed of special asphalts or similar materials blended with lubricating and plasticizing agents to form a tough, durable mastic substance containing no volatile oils or lubricants.

2.4 MISCELLANEOUS MATERIALS

- A. Dampproofing agent shall be an asphalt emulsion.
- B. Bonding agents shall be epoxy adhesives.

2.5 CONCRETE DESIGN REQUIREMENTS

- A. **General:** Concrete shall be composed of cement, admixtures, aggregates and water. These materials shall be of the qualities specified. The exact proportions in which these materials are to be used for different parts of the work will be determined during the trial batch. In general, the mix shall be designed to produce a concrete capable of being deposited so as to obtain maximum density and minimum shrinkage and, where deposited in forms, to have good consolidation properties and maximum smoothness of surface. In mix designs, the percentage of sand of the total weight of fine and coarse aggregate shall not exceed 41 for hydraulic structures or 50 for all other structures, unless noted otherwise. The aggregate gradations shall be formulated to provide fresh concrete that will not promote rock pockets around reinforcing steel or embedded items. The proportions shall be changed whenever necessary or desirable to meet the required results at no additional cost to the OWNER. All changes shall be subject to review by the CONSTRUCTION MANAGER.
- B. **Water-Cement Ratio and Compressive Strength:** The minimum compressive strength and cement content of concrete shall be not less than that specified in the following tabulation.

<u>Type of Work</u>	<u>Min 28-Day Compr. Strength (psi)</u>	<u>Max Size Aggregate (in)</u>	<u>Minimum Cement per cu yd (lbs)</u>	<u>Max W/C Ratio (by weight)</u>
Structural Concrete:				
Roof, floor slabs, columns, walls and all other concrete items not specified elsewhere.	4,000	1	564	0.45
12" and thicker walls, slabs on grade and footings. (optional)	4,000	1-1/2	564	0.45
Pea Gravel Mix. Thin sections and areas with congested reinforcing, at the CONTRACTOR'S option and with the written approval of the CONSTRUCTION MANAGER for the specific location. Maximum fine aggregate 50% by weight of aggregate.	4,000	3/8	752	0.40
Lean concrete	2,000	1	376	0.60

Note: The CONTRACTOR is cautioned that the limiting parameters specified above are not a mix design. Additional cement or water reducing agent may be required to achieve workability demanded by the CONTRACTOR'S construction methods and aggregates. The CONTRACTOR is responsible for any costs associated with furnishing concrete with the required workability.

- C. **Adjustments to Mix Design:** The mixes used shall be changed whenever such change is necessary or desirable to secure the required strength, density, workability, and surface finish and the CONTRACTOR shall be entitled to no additional compensation because of such changes.

2.6 CONSISTENCY

- A. The quantity of water entering into a batch of concrete shall be just sufficient, with a normal mixing period, to produce a concrete which can be worked properly into place without segregation, and which can be compacted by the vibratory methods herein specified to give the desired density, impermeability and smoothness of surface. The quantity of water shall be changed as necessary, with variations in the nature or moisture content of the aggregates, to maintain uniform production of a desired consistency. The consistency of the concrete in successive batches shall be determined by slump tests in accordance with ASTM C 143. The slumps shall be as follows:

<u>Part of Work</u>	<u>Slump (in)</u>
All concrete, unless noted otherwise	3 inches \pm 1 inch
With high range water reducer added	7 inches \pm 2 inches
Pea gravel mix	7 inches \pm 2 inches
Ductbanks	5 inches \pm 1 inch

2.7 TRIAL BATCH AND LABORATORY TESTS

- A. Before placing any concrete, a testing laboratory designated by the CONSTRUCTION MANAGER shall prepare a trial batch of each class of structural concrete, based on the preliminary concrete mixes submitted by the CONTRACTOR. During the trial batch the aggregate proportions may be adjusted by the testing laboratory using the two coarse aggregate size ranges to obtain the required properties. If one size range produces an acceptable mix, a second size range need not be used. Such adjustments shall be considered refinements to the mix design and shall not be the basis for extra compensation to the CONTRACTOR. All concrete shall conform to the requirements of this Section, whether the aggregate proportions are from the CONTRACTOR's preliminary mix design, or whether the proportions have been adjusted during the trial batch process. The trial batch shall be prepared using the aggregates, cement and admixture proposed for the project. The trial batch materials shall be of a quantity such that the testing laboratory can obtain 3 drying shrinkage, and 6 compression test specimens from each batch. The cost of not more than 3 laboratory trial batch tests for each specified concrete strength will be borne by the OWNER but the CONTRACTOR shall furnish and deliver the materials in steel drums at no cost. Any additional trial batch testing required shall be performed at the expense of the CONTRACTOR at no increase in cost to the OWNER.
- B. The determination of compressive strength will be made by testing 6-inch diameter by 12-inch high cylinders; made, cured and tested in accordance with ASTM C 192 and ASTM C 39. Three compression test cylinders will be tested at 7 days and 3 at 28 days. The average compressive strength for the 3 cylinders tested at 28 days for any given trial batch shall not be less than 125 percent of the specified compressive strength.
- C. A sieve analysis of the combined aggregate for each trial batch shall be performed according to the requirements of ASTM C 136. Values shall be given for percent passing each sieve.

2.8 SHRINKAGE LIMITATION

- A. The maximum concrete shrinkage for specimens cast in the laboratory from the trial batch, as measured at 21-day drying age or at 28-day drying age shall be 0.036 percent or 0.042 percent,

respectively. The CONTRACTOR shall only use a mix design for construction that has first met the trial batch shrinkage requirements. Shrinkage limitations apply only to structural concrete.

- B. The maximum concrete shrinkage for specimens cast in the field shall not exceed the trial batch maximum shrinkage requirement by more than 25 percent.
- C. If the required shrinkage limitation is not met during construction, the CONTRACTOR shall take any or all of the following actions, at no additional cost to the OWNER, for securing the specified shrinkage requirements. These actions may include changing the source or aggregates, cement and/or admixtures; reducing water content; washing of aggregate to reduce fines; increasing the number of construction joints; modifying the curing requirements; or other actions designed to minimize shrinkage or the effects of shrinkage.

2.9 MEASUREMENT OF CEMENT AND AGGREGATE

- A. The amount of cement and of each separate size of aggregate entering into each batch of concrete shall be determined by direct weighing equipment furnished by the CONTRACTOR and acceptable to the CONSTRUCTION MANAGER.
- B. Weighing tolerances:

Material	Percent of total weight
Cement	1
Aggregates	3
Admixtures	3

2.10 MEASUREMENT OF WATER

- A. The quantity of water entering the mixer shall be measured by a suitable water meter or other measuring device of a type acceptable to the CONSTRUCTION MANAGER and capable of measuring the water in variable amounts within a tolerance of one percent. The water feed control mechanism shall be capable of being locked in position so as to deliver constantly any specified amount of water to each batch of concrete. A positive quick-acting valve shall be used for a cut-off in the water line to the mixer. The operating mechanism must be such that leakage will not occur when the valves are closed.

2.11 READY-MIXED CONCRETE

- A. At the CONTRACTOR'S option, ready-mixed concrete may be used meeting the requirements as to materials, batching, mixing, transporting, and placing as specified herein and in accordance with ASTM C 94, including the following supplementary requirements.
- B. Ready-mixed concrete shall be delivered to the site of the work, and discharge shall be completed within one hour after the addition of the cement to the aggregates or before the drum has been revolved 250 revolutions, whichever is first.

- C. Truck mixers shall be equipped with electrically-actuated counters by which the number of revolutions of the drum or blades may be readily verified. The counter shall be of the resettable, recording type, and shall be mounted in the driver's cab. The counters shall be actuated at the time of starting mixers at mixing speeds.
- D. Each batch of concrete shall be mixed in a truck mixer for not less than 70 revolutions of the drum or blades at the rate of rotation designated by the manufacturer of equipment. Additional mixing, if any, shall be at the speed designated by the manufacturer of the equipment as agitating speed. All materials including mixing water shall be in the mixer drum before actuating the revolution counter for determining the number of revolutions of mixing.
- E. Truck mixers and their operation shall be such that the concrete throughout the mixed batch as discharged is within acceptable limits of uniformity with respect to consistency, mix, and grading. If slump tests taken at approximately the 1/4 and 3/4 points of the load during discharge give slumps differing by more than one inch when the specified slump is 3 inches or less, or if they differ by more than 2 inches when the specified slump is more than 3 inches, the mixer shall not be used on the work unless the causing condition is corrected and satisfactory performance is verified by additional slump tests. All mechanical details of the mixer, such as water measuring and discharge apparatus, condition of the blades, speed of rotation, general mechanical condition of the unit, and clearance of the drum, shall be checked before a further attempt to use the unit will be permitted.
- F. Each batch of ready-mixed concrete delivered at the job site shall be accompanied by a delivery ticket furnished to the CONSTRUCTION MANAGER.
- G. The use of non-agitating equipment for transporting ready-mixed concrete will not be permitted. Combination truck and trailer equipment for transporting ready-mixed concrete will not be permitted. The quality and quantity of materials used in ready-mixed concrete and in batch aggregates shall be subject to continuous inspection at the batching plant by the CONSTRUCTION MANAGER.

2.12 MANUFACTURERS

- A. Products shall be manufactured by one of the following (or equal):

- 1. Air Entraining Agent

Micro-Air by Master Builders
Daravair by W.R. Grace
Sika AEA-15 by Sika Corporation

- 2. Set Retarding Admixture

Plastocrete by Sika Corporation
Pozzolith 300R by Master Builders
Daratard by W.R. Grace

- 3. Set Accelerating Admixture

Plastocrete 161FL by Sika Corporation
Pozzutec 20 by Master Builders
Daraset by W.R. Grace

4. Normal Range Water Reducer

WRDA 79 by W.R. Grace
Pozzolith 322-N by Master Builders
Plastocrete 161 by Sika Corporation

5. High Range Water Reducer

Daracem 100 or WRDA 19 by W.R. Grace
Sikament FF or Sikament 86 by Sika Corporation
Rheobuild 1000 or Rheobuild 716 by Master Builders

6. Curing Compound

Aqua Resincure by Burke
Aqua-cure by Euclid Chemical Company
Masterkure-W by Master Builders

7. Evaporation Retardant

Confilm by Master Builders
Eucobar by Euclid Chemical Company

8. Dampproofing Agent

Hydrocide 600 by Sonneform
Sealmastic by W.R. Meadows
Damp proofing Asphalt Coating by Euclid Chemical Company

9. Agents for Bonding Freshly-Mixed Plastic Concrete to Hardened Concrete

Sikadur 32 Hi-Mod Epoxy Adhesive by Sika Corporation
Concresive liquid (LPL) by Master Builders
BurkEpoxy MV by Burke

10. Agents for Bonding Hardened Concrete to Steel

Sikadur 31 Hi-Mod Gel by Sika Corporation
BurkEpoxy NS by Burke
Concresive Paste (LPL) by Master Builders

11. White Portland Cement

Atlas White

PART 3 -- EXECUTION

3.1 PROPORTIONING AND MIXING

- A. **Proportioning:** Proportioning of the concrete mix shall conform to the requirements of Chapter 3 "Proportioning" of ACI 301.

- B. **Mixing:** Mixing of concrete shall conform to the requirements of Chapter 7 of ACI 301.
- C. **Slump:** Maximum slumps shall be as indicated.
- D. **Retempering:** Retempering of concrete or mortar which has partially hardened shall not be permitted.

3.2 PREPARATION OF SURFACES FOR CONCRETING

- A. **General:** Earth surfaces shall be thoroughly wetted by sprinkling, prior to the placing of any concrete, and these surfaces shall be kept moist by frequent sprinkling up to the time of placing concrete thereon. The surface shall be free from standing water, mud, and debris at the time of placing concrete.
- B. **Joints in Concrete up to 60 Days Old:** Concrete surfaces upon or against which concrete is to be placed, where the placement of the concrete has been stopped or interrupted so that, as determined by the CONSTRUCTION MANAGER, the new concrete cannot be incorporated integrally with that previously placed, are defined as construction joints. The surfaces of horizontal joints shall be given a compacted, roughened surface for good bond. Except where the Drawings call for joint surfaces to be coated, the joint surfaces shall be cleaned of all laitance, loose or defective concrete, foreign material, and roughened to a minimum 1/4-inch amplitude. Such cleaning and roughening shall be accomplished by hydroblasting or sandblasting (exposing aggregate) followed by thorough washing. All pools of water shall be removed from the surface of construction joints before the new concrete is placed.
- C. After the surfaces have been prepared all approximately horizontal construction joints shall be covered with a 6-inch lift of the pea gravel mix indicated above. The mix shall be placed and spread uniformly. Wall concrete shall follow immediately and shall be placed upon the fresh pea gravel mix.
- D. **Placing Interruptions:** When placing of concrete is to be interrupted long enough for the concrete to take a set, the working face shall be given a shape by the use of forms or other means, that will secure proper union with subsequent work; provided that construction joints shall be made only where acceptable to the CONSTRUCTION MANAGER.
- E. **Embedded Items:** No concrete shall be placed until all formwork, installation of parts to be embedded, reinforcement steel, and preparation of surfaces involved in the placing have been completed and accepted by the CONSTRUCTION MANAGER at least 4 hours before placement of concrete. All surfaces of forms and embedded items that have become encrusted with dried grout from concrete previously placed shall be cleaned of all such grout before the surrounding or adjacent concrete is placed.
- F. All inserts or other embedded items shall conform to the requirements herein.
- G. All reinforcement, anchor bolts, sleeves, inserts, and similar items shall be set and secured in the forms where shown or by shop drawings and shall be acceptable to the CONSTRUCTION MANAGER before any concrete is placed. Accuracy of placement is the responsibility of the CONTRACTOR.
- H. **Casting New Concrete Against Concrete over 60 Days Old:** Where concrete is to be cast against old concrete (any concrete which is greater than 60 days of age), the surface of the old concrete shall be thoroughly cleaned and roughened by hydro-blasting or sandblasting (exposing aggregate). The

joint surface shall be coated with an epoxy bonding agent unless indicated otherwise by the CONSTRUCTION MANAGER.

- I. No concrete shall be placed in any structure until all water entering the space to be filled with concrete has been properly cut off or has been diverted by pipes, or other means, and carried out of the forms, clear of the work. No concrete shall be deposited underwater nor shall the CONTRACTOR allow still water to rise on any concrete until the concrete has attained its initial set. Water shall not be permitted to flow over the surface of any concrete in such manner and at such velocity as will injure the surface finish of the concrete. Pumping or other necessary dewatering operations for removing ground water, if required, will be subject to the review of the CONSTRUCTION MANAGER.
- J. **Corrosion Protection:** Pipe, conduit, dowels, and other ferrous items required to be embedded in concrete construction shall be so positioned and supported prior to placement of concrete that there will be a minimum of 2 inches clearance between said items and any part of the concrete reinforcement. Securing such items in position by wiring or welding them to the reinforcement will not be permitted.
- K. Openings for pipes, inserts for pipe hangers and brackets, and the setting of anchors shall, where practicable, be provided for during the placing of concrete.
- L. Anchor bolts shall be accurately set, and shall be maintained in position by templates while being embedded in concrete.
- M. **Cleaning:** The surfaces of all metalwork to be in contact with concrete shall be thoroughly cleaned of all dirt, grease, loose scale and rust, grout, mortar, and other foreign substances immediately before the concrete is placed.

3.3 HANDLING, TRANSPORTING, AND PLACING

- A. **General:** Placing of concrete shall conform to the applicable requirements of Chapter 8 of ACI 301 and the requirements of this Section. No aluminum materials shall be used in conveying any concrete.
- B. **Non-Conforming Work or Materials:** Concrete which upon or before placing is found not to conform to the requirements specified herein shall be rejected and immediately removed from the work. Concrete which is not placed in accordance with these Specifications, or which is of inferior quality, shall be removed and replaced by the CONTRACTOR at no additional cost to the OWNER.
- C. **Unauthorized Placement:** No concrete shall be placed except in the presence of duly authorized representative of the CONSTRUCTION MANAGER. The CONTRACTOR shall notify the CONSTRUCTION MANAGER in writing at least 24 hours in advance of placement of any concrete.
- D. **Placement in Wall Forms:** Concrete shall not be dropped through reinforcement steel or into any deep form, nor shall concrete be placed in any form in such a manner as to leave accumulation of mortar on the form surfaces above the placed concrete. In such cases, some means such as the use of hoppers and, if necessary, vertical ducts of canvas, rubber, or metal shall be used for placing concrete in the forms in a manner that it may reach the place of final deposit without separation. In no case shall the free fall of concrete exceed 4 feet below the ends of ducts, chutes, or buggies. Concrete shall be uniformly distributed during the process of depositing and in no case after depositing shall any portion be displaced in the forms more than 6 feet in horizontal direction. Concrete in forms shall be deposited in uniform horizontal layers not deeper than 2 feet; and care

shall be taken to avoid inclined layers or inclined construction joints except where such are required for sloping members. Each layer shall be placed while the previous layer is still soft. The rate of placing concrete in forms shall not exceed 5 feet of vertical rise per hour. Sufficient illumination shall be provided in the interior of all forms so that the concrete at the places of deposit is visible from the deck or runway.

- E. **Conveyor Belts and Chutes:** All ends of chutes, hopper gates, and all other points of concrete discharge throughout the CONTRACTOR'S conveying, hoisting and placing system shall be so designed and arranged that concrete passing from them will not fall separated into whatever receptacle immediately receives it. Conveyor belts, if used, shall be of an acceptable type. Chutes longer than 50 feet will not be permitted. Minimum slopes of chutes shall be such that concrete of the specified consistency will readily flow in them. If a conveyor belt is used, it shall be wiped clean by a device operated in such a manner that none of the mortar adhering to the belt will be wasted. All conveyor belts and chutes shall be covered.
- F. **Placement in Slabs:** Concrete placed in sloping slabs shall proceed uniformly from the bottom of the slab to the top, for the full width of the placement. As the work progresses, the concrete shall be vibrated and carefully worked around the slab reinforcement, and the surface of the slab shall be screeded in an up-slope direction.
- G. **Temperature of Concrete:** The temperature of concrete when it is being placed shall be not more than 90 degrees F nor less than 55 degrees F for sections less than 12 inches thick nor less than 50 degrees for all other sections. Concrete ingredients shall not be heated to a temperature higher than that necessary to keep the temperature of the mixed concrete, as placed, from falling below the specified minimum temperature. When the temperature of the concrete is 85 degrees F or above, the time between the introduction of the cement to the aggregates and discharge shall not exceed 45 minutes. If concrete is placed when the weather is such that the temperature of the concrete would exceed 90 degrees F, the CONTRACTOR shall employ effective means, such as precooling of aggregates and mixing water using ice or placing at night, as necessary to maintain the temperature of the concrete, as it is placed, below 90 degrees F. The CONTRACTOR shall be entitled to no additional compensation on account of the foregoing requirements.
- [H. **Cold Weather Placement:** Remove all snow, ice and frost from the surfaces, including reinforcement, against which concrete is to be placed. Before beginning concrete placement, thaw the subgrade to a minimum depth of 6 inches. All reinforcement and embedded items shall be warmed to above 32 degrees F prior to concrete placement.]

3.4 PUMPING OF CONCRETE

- A. **General:** If the pumped concrete does not produce satisfactory end results, the CONTRACTOR shall discontinue the pumping operation and proceed with the placing of concrete using conventional methods.
- B. **Pumping Equipment:** The pumping equipment must have 2 cylinders and be designed to operate with one cylinder only in case the other one is not functioning. In lieu of this requirement, the CONTRACTOR may have a standby pump on the site during pumping.
- C. The minimum diameter of the hose (conduits) shall be in accordance with ACI 304.2R.
- D. Pumping equipment and hoses (conduits) that are not functioning properly, shall be replaced.
- E. Aluminum conduits for conveying the concrete shall not be permitted.

- F. **Field Control:** Concrete samples for slump, air content, and test cylinders will be taken at the placement (discharge) end of the line.

3.5 ORDER OF PLACING CONCRETE

- A. The order of placing concrete in all parts of the work shall be acceptable to the CONSTRUCTION MANAGER. In order to minimize the effects of shrinkage, the concrete shall be placed in units as bounded by construction joints shown. The placing of units shall be done by placing alternate units in a manner such that each unit placed shall have cured at least 7 days for hydraulic structures and 3 days for all other structures before the contiguous unit or units are placed, except that the corner sections of vertical walls shall not be placed until the 2 adjacent wall panels have cured at least 14 days for hydraulic structures and 7 days for all other structures.
- B. The surface of the concrete shall be level whenever a run of concrete is stopped. To insure a level, straight joint on the exposed surface of walls, a wood strip at least 3/4-inch thick shall be tacked to the forms on these surfaces. The concrete shall be carried about 1/2-inch above the underside of the strip. About one hour after the concrete is placed, the strip shall be removed and any irregularities in the edge formed by the strip shall be leveled with a trowel and all laitance shall be removed.

3.6 TAMPING AND VIBRATING

- A. As concrete is placed in the forms or in excavations, it shall be thoroughly settled and compacted, throughout the entire depth of the layer which is being consolidated, into a dense, homogeneous mass, filling all corners and angles, thoroughly embedding the reinforcement, eliminating rock pockets, and bringing only a slight excess of water to the exposed surface of concrete during placement. Vibrators shall be Group 3 (per ACI 309) high speed power vibrators (8000 to 12,000 rpm) of an immersion type in sufficient number and with (at least one) standby units as required. Group 2 vibrators may be used only at specific locations when accepted by the CONSTRUCTION MANAGER.
- B. Care shall be used in placing concrete around waterstops. The concrete shall be carefully worked by rodding and vibrating to make sure that all air and rock pockets have been eliminated. Where flat-strip type waterstops are placed horizontally, the concrete shall be worked under the waterstops by hand, making sure that all air and rock pockets have been eliminated. Concrete surrounding the waterstops shall be given additional vibration, over and above that used for adjacent concrete placement to assure complete embedment of the waterstops in the concrete.
- C. Concrete in walls shall be internally vibrated and at the same time rammed, stirred, or worked with suitable appliances, tamping bars, shovels, or forked tools until it completely fills the forms or excavations and closes snugly against all surfaces. Subsequent layers of concrete shall not be placed until the layers previously placed have been worked thoroughly as specified. Vibrators shall be provided in sufficient numbers, with standby units as required, to accomplish the results herein specified within 15 minutes after concrete of the prescribed consistency is placed in the forms. The vibrating head shall be kept from contact with the surfaces of the forms. Care shall be taken not to vibrate concrete excessively or to work it in any manner that causes segregation of its constituents.

3.7 FINISHING CONCRETE SURFACES

- A. **General:** Surfaces shall be free from fins, bulges, ridges, offsets, honeycombing, or roughness of any kind, and shall present a finished, smooth, continuous hard surface. Allowable deviations from plumb or level and from the alignment, profiles, and dimensions shown are defined as tolerances and

were indicated above. Tolerances are to be distinguished from irregularities in finish as described below. Aluminum finishing tools shall not be used.

- B. **Formed Surfaces:** No treatment is required after form removal except for curing, repair of defective concrete, and treatment of surface defects. Where architectural finish is required, it shall be as indicated.

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NTS: Chose one of the following:

1. Surface holes larger than [1/2]inch in diameter or deeper than [1/4]inch are defined as surface defects in basins and exposed walls.
- [2. The OWNER has identified an acceptable wall finish on an identified panel at an existing structure to be used as a comparative sample for formed finish without architectural treatment. This panel is located []. At walls which are exposed to view or in contact with water, surface roughness or surface holes, greater than the identified panel considering both size and number per unit surface area as separate criteria, shall be considered to have surface defects and shall be repaired to match or exceed the sample finish.]
- [3. Basins and exposed walls shall be given a smooth finish as indicated below.]
- [4. Basins and exposed walls shall be given two coats of cement based paint as indicated.]

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- C. **Unformed Surfaces:** After proper and adequate vibration and tamping, all unformed top surfaces of slabs, floors, walls, and curbs shall be brought to a uniform surface with suitable tools. Immediately after the concrete has been screeded, it shall be treated with a liquid evaporation retardant. The retardant shall be used again after each work operation as necessary to prevent drying shrinkage cracks. The classes of finish specified for unformed concrete surfaces are designated and defined as follows:

1. Finish U1 - Sufficient leveling and screeding to produce an even, uniform surface with surface irregularities not to exceed 3/8-inch. No further special finish is required.
2. Finish U2 - After sufficient stiffening of the screeded concrete, surfaces shall be float finished with wood or metal floats or with a finishing machine using float blades. Excessive floating of surfaces while the concrete is plastic and dusting of dry cement and sand on the concrete surface to absorb excess moisture will not be permitted. Floating shall be the minimum necessary to produce a surface that is free from screed marks and is uniform in texture. Surface irregularities shall not exceed 1/4-inch. Joints and edges shall be tooled where shown or as determined by the CONSTRUCTION MANAGER.
3. Finish U3 - After the floated surface (as specified for Finish U2) has hardened sufficiently to prevent excess of fine material from being drawn to the surface, steel troweling shall be performed with firm pressure such as will flatten the sandy texture of the floated surface and

produce a dense, uniform surface free from blemishes, ripples, and trowel marks. The finish shall be smooth and free of all irregularities.

4. Finish U4 - Steel trowel finish (as specified for Finish U3) without local depressions or high points. In addition, the surface shall be given a light hairbroom finish with brooming perpendicular to drainage unless otherwise shown. The resulting surface shall be rough enough to provide a nonskid finish.

D. Unformed surfaces shall be finished according to the following schedule:

UNFORMED SURFACE FINISH SCHEDULE

Area	<u>Finish</u>
Grade slabs and foundations to be covered with concrete or fill material	U1
Floors to be covered with grouted tile or topping grout	U2
Slabs which are water bearing with slopes 10 percent and less	U3
Sloping slabs which are water bearing with slopes greater than 10 percent	U4
Slabs not water bearing	U4
Slabs to be covered with built-up roofing	U2
Interior slabs and floors to receive architectural finish	U3
Top surface of walls	U3

E. Floor Sealer/Hardener (Surface Applied):

1. Floors to receive hardener shall be cured, cleaned, and dry with all work above them completed. Not less than 60 days shall have elapsed between casting floors and application of sealer/hardener. Apply zinc and/or magnesium fluosilicate evenly, using 3 coats, allowing 24 hours between coats.
2. The first coat shall be 1/3 strength, second coat 1/2 strength, and third coat 2/3 strength. Each coat shall be applied so as to remain wet on the concrete surface for 15 minutes. If sodium silicate is used, it shall be applied evenly, using 3 coats, allowing 24 hours between coats, and the material shall be applied full strength at the rate of one gallon per 300 square feet. Approved proprietary hardeners shall be applied in conformance with the manufacturer's instruction. After the final coat is completed and dry, surplus hardener shall be removed from the surface by scrubbing and mopping with water.
3. Floor hardener shall be applied where shown.

3.8 ARCHITECTURAL FINISH

A. **General:** Architectural finishes shall be required only where specifically indicated. In all other cases the requirements above shall apply.

1. Immediately after the forms have been stripped, the concrete surface shall be inspected and any poor joints, voids, rock pockets, or other defective areas shall be repaired and all form-tie holes filled as specified herein.
2. Architectural finishes shall not be applied until the concrete surface has been repaired as required and the concrete has cured at least 14 days.
3. All architecturally treated concrete surfaces shall conform to the accepted sample required herein in texture, color, and quality. It shall be the CONTRACTOR's responsibility to maintain and protect the concrete finish.

B. **Smooth Concrete Finish**

1. The concrete surface shall be wetted, and a grout shall be applied with a brush. The grout shall be made by mixing one part portland cement and one part of fine sand that will pass a No. 16 sieve with sufficient water to give it the consistency of thick paint. The cement used in said grout shall be 1/2 gray and 1/2 white portland cement, as determined by the CONSTRUCTION MANAGER. Calcium chloride in the amount of 5 percent by volume of the cement shall be used in the brush coat. The freshly applied grout shall be vigorously rubbed into the concrete surface with a wood float filling all small air holes. After all the surface grout had been removed with a steel trowel, the surface shall be allowed to dry and, when dry, shall be vigorously rubbed with burlap to remove completely all surface grout so that there is no visible paint-like film of grout on the concrete. The entire cleaning operation for any area shall be completed the day it is started, and no grout shall be left on the surface overnight.
2. Cleaning operations for any given day shall be terminated at panel joints. It is essential that the various operations be carefully timed to secure the desired effect which is a light-colored concrete surface of uniform color and texture without any appearance of a paint or grout film.
3. In the event that improper manipulation results in an inferior finish, the CONTRACTOR shall rub such inferior areas with carborundum bricks.
4. Before beginning any of the final treatment on exposed surfaces, the CONTRACTOR shall treat in a satisfactory manner a trial area of at least 200 square feet in some inconspicuous place selected by the CONSTRUCTION MANAGER and shall preserve said trial area undisturbed until the completion of the job.

C. **Sandblasted Concrete Finish**

1. Sandblasting shall be done in a safe manner acceptable to local authorities and per OSHA requirements. The sandblasting shall be a light sandblast to remove laitance and to produce a uniform fine aggregate surface texture with approximately 1/32- to 1/16-inch of surface sandblasted off. Corners, patches, form panel joints, and soft spots shall be sandblasted with care.
2. A 3-sq ft sample panel of the sandblasted finish shall be provided by the CONTRACTOR for acceptance prior to starting the sandblasting work. The sample panel shall include a corner,

plugs, and joints and shall be marked after approval. All other sandblasting shall be equal in finish to the sample panel.

3. Protection against sandblasting shall be provided on all surfaces and materials not requiring sandblasting but within or adjacent to areas being sandblasted. After sandblasting, the concrete surfaces shall be washed with clean water and excess sand removed.

3.9 CURING AND DAMPPROOFING

- A. **General:** All concrete shall be cured for not less than 14 days after placing, in accordance with the methods specified herein for the different parts of the work, and described in detail in the following paragraphs:

<u>Surface to be Cured or Dampproofed</u>	<u>Method</u>
Unstripped forms	1
Wall sections with forms removed	4 or 6
Construction joints between footings and walls, and between floor slab and columns	2
Encasement concrete and thrust blocks	3
All concrete surfaces not specifically provided for elsewhere in this Paragraph	4
Floor slabs on grade in hydraulic structures	5
Slabs not on grade	6

- B. **Method 1:** Wooden forms shall be wetted immediately after concrete has been placed and shall be kept wet with water until removed. If steel forms are used the exposed concrete surfaces shall be kept continuously wet until the forms are removed. If forms are removed within 14 days of placing the concrete, curing shall be continued in accordance with Method 6, herein.
- C. **Method 2:** The surface shall be covered with burlap mats which shall be kept wet with water for the duration of the curing period, until the concrete in the walls has been placed. No curing compound shall be applied to surfaces cured under Method 2.
- D. **Method 3:** The surface shall be covered with moist earth not less than 4 hours, nor more than 24 hours, after the concrete is placed. Earthwork operations that may damage the concrete shall not begin until at least 7 days after placement of concrete.
- E. **Method 4:** The surface shall be sprayed with a liquid curing compound.
1. Curing compound shall not be used on concrete surfaces to be coated, waterproofed, moistureproofed, or where any coverings are to be bonded.
 2. It shall be applied in accordance with the manufacturer's printed instructions at a maximum coverage rate of 200 square feet per gallon and in such a manner as to cover the surface with a uniform film which will seal thoroughly.

3. Where the curing compound method is used, care shall be exercised to avoid damage to the seal during the curing period. Should the seal be damaged or broken before the expiration of the curing period, the break shall be repaired immediately by the application of additional curing compound over the damaged portion.
4. Wherever curing compound may have been applied by mistake to surfaces against which concrete subsequently is to be placed and to which it is to adhere, said compound shall be entirely removed by wet sandblasting just prior to the placing of new concrete.
5. Where curing compound is specified, it shall be applied as soon as the concrete has hardened enough to prevent marring on unformed surfaces, and within 2 hours after removal of forms from contact with formed surfaces. Repairs required to be made to formed surfaces shall be made within the said 2-hour period; provided, however, that any such repairs which cannot be made within the said 2-hour period shall be delayed until after the curing compound has been applied. When repairs are to be made to an area on which curing compound has been applied, the area involved shall first be wet-sandblasted to remove the curing compound, following which repairs shall be made as specified herein.
6. At all locations where concrete is placed adjacent to a panel which has been coated with curing compound, the previously coated panel shall have curing compound reapplied to an area within 6 feet of the joint and to any other location where the curing membrane has been disturbed.
7. Prior to final acceptance of the WORK, all visible traces of curing compound shall be removed from all surfaces in such a manner that does not damage surface finish.

F. Method 5:

1. Until the concrete surface is covered with curing compound, the entire surface shall be kept damp by applying water using nozzles that atomize the flow so that the surface is not marred or washed. The concrete shall be given a coat of curing compound in accordance with Method 4, herein. Not less than one hour nor more than 4 hours after the coat of curing compound has been applied, the surface shall be wetted with water delivered through a fog nozzle, and concrete-curing blankets shall be placed on the slabs. The curing blankets shall be polyethylene sheet, polyethylene-coated waterproof paper sheeting or polyethylene-coated burlap. The blankets shall be laid with the edges butted together and with the joints between strips sealed with 2-inch wide strips of sealing tape or with edges lapped not less than 3 inches and fastened together with a waterproof cement to form a continuous watertight joint.
2. The curing blankets shall be left in place during the 14-day curing period and shall not be removed until after concrete for adjacent work has been placed. Should the curing blankets become torn or otherwise ineffective, the CONTRACTOR shall replace damaged sections. During the first 3 days of the curing period, no traffic of any nature and no depositing, temporary or otherwise, of any materials shall be permitted on the curing blankets. During the remainder of the curing period, foot traffic and temporary depositing of materials that impose light pressure will be permitted only on top of plywood sheets 5/8-inch minimum thickness, laid over the curing blanket. The CONTRACTOR shall add water under the curing blanket as often as necessary to maintain damp concrete surfaces at all times.

G. Method 6:

1. The concrete shall be kept continuously wet by the application of water for a minimum period of at least 14 consecutive days beginning immediately after the concrete has reached final set or forms have been removed.
2. Until the concrete surface is covered with the curing medium, the entire surface shall be kept damp by applying water using nozzles that atomize the flow so that the surface is not marred or washed.
3. Heavy curing mats shall be used as a curing medium to retain the moisture during the curing period. The curing medium shall be weighted or otherwise held in place to prevent being dislodged by wind or any other causes and to be substantially in contact with the concrete surface. All edges shall be continuously held in place.
4. The curing blankets and concrete shall be kept continuously wet by the use of sprinklers or other means both during and after normal working hours.
5. Immediately after the application of water has terminated at the end of the curing period, the curing medium shall be removed, any dry spots shall be rewetted, and curing compound shall be immediately applied in accordance with Method 4, herein.
6. The CONTRACTOR shall dispose of excess water from the curing operation to avoid damage to the work.

H. Dampproofing

1. The exterior surface of all buried roof slabs shall be dampproofed as follows.
2. Immediately after completion of curing the surface shall be sprayed with a dampproofing agent consisting of an asphalt emulsion. Application shall be in 2 coats. The first coat shall be diluted to 1/2 strength by the addition of water and shall be sprayed on so as to provide a maximum coverage rate of 100 square feet per gallon of dilute solution. The second coat shall consist of an application of the specified material, undiluted, and shall be sprayed on so as to provide a maximum coverage rate of 100 square feet per gallon. Dampproofing material shall be as specified herein.
3. As soon as the asphalt emulsion, applied as specified herein, has taken an initial set, the entire area thus coated shall be coated with whitewash. Any formula for mixing the whitewash may be used which produces a uniformly coated white surface and which so remains until placing of the backfill. Should the whitewash fail to remain on the surface until the backfill is placed, the CONTRACTOR shall apply additional whitewash.

3.10 PROTECTION

- A. The CONTRACTOR shall protect all concrete against injury until final acceptance by the OWNER.
- B. Fresh concrete shall be protected from damage due to rain. The CONTRACTOR shall provide such protection while the concrete is still plastic and whenever such precipitation is imminent or occurring.

[3.11 CURING AND THERMAL PROTECTION IN COLD WEATHER

- A. The CONTRACTOR shall be prepared to protect all concrete against freezing. After the first frost or when the mean daily temperature in the vicinity of the worksite falls below 40 degrees F for more than one day, the concrete shall be maintained at a temperature not lower than 50 degrees F for at least 72 hours after it is placed.
- B. Water curing of concrete may be reduced to 6 days during periods when the mean daily temperature in the vicinity of the worksite is less than 40 degrees F. The concrete shall be maintained at not less than 50 degrees F for the entire curing period.
- C. Discontinuance of protection against freezing temperatures shall be such that the drop in temperature of any portion of the concrete will be gradual and will not exceed 40 degrees F in 24 hours. In the spring, when the mean daily temperature rises above 40 degrees F for more than 3 successive days, the specified 72-hour protection at a temperature not lower than 50 degrees F may be discontinued for as long as the mean daily temperature remains above 40 degrees F; provided, that the concrete shall be protected against freezing temperatures for not less than 48 hours after placement.
- D. Where artificial heat is employed, special care shall be taken to prevent the concrete from drying. Use of unvented heaters will be permitted only when unformed surfaces of concrete adjacent to the heaters are protected for the first 24 hours from an excessive carbon dioxide atmosphere by application of curing compound; provided, that the use of curing compound for such surfaces is otherwise permitted by these Specifications.]

3.12 TREATMENT OF SURFACE DEFECTS

- A. As soon as forms are removed, all exposed surfaces shall be carefully examined and any irregularities shall be immediately rubbed or ground in a satisfactory manner in order to secure a smooth, uniform, and continuous surface. Plastering or coating of surfaces to be smoothed will not be permitted. No repairs shall be made until after inspection by the CONSTRUCTION MANAGER. In no case will extensive patching of honeycombed concrete be permitted. Concrete containing minor voids, holes, honeycombing, or similar depression defects shall have them repaired as specified herein. Concrete containing extensive voids, holes, honeycombing, or similar depression defects, shall be completely removed and replaced. All repairs and replacements herein specified shall be promptly executed by the CONTRACTOR at its own expense.
- B. Defective surfaces to be repaired shall be cut back from trueline a minimum depth of 1/2-inch over the entire area. Feathered edges will not be permitted. Where chipping or cutting tools are not required in order to deepen the area properly, the surface shall be prepared for bonding by the removal of all laitance or soft material, and not less than 1/32-inch depth of the surface film from all hard portions, by means of an efficient sandblast. After cutting and sandblasting, the surface shall be wetted sufficiently in advance of shooting with shotcrete or with cement mortar so that while the repair material is being applied, the surfaces under repair will remain moist, but not so wet as to overcome the suction upon which a good bond depends. The material used for repair proposed shall consist of a mixture of one sack of cement to 3 cubic feet of sand. For exposed walls, the cement shall contain such a proportion of Atlas white portland cement as is required to make the color of the patch match the color of the surrounding concrete.

- C. Holes left by tie-rod cones shall be reamed with suitable toothed reamers so as to leave the surfaces of the holes clean and rough. These holes then shall be repaired in an approved manner with dry-packed cement grout. Holes left by form-tying devices having a rectangular cross-section, and other imperfections having a depth greater than their least surface dimension, shall not be reamed but shall be repaired in an approved manner with dry-packed cement grout.
- D. All repairs shall be built up and shaped in such a manner that the completed work will conform to the requirements of this Section, as applicable, using approved methods which will not disturb the bond, cause sagging, or cause horizontal fractures. Surfaces of said repairs shall receive the same kind and amount of curing treatment as required for the concrete in the repaired section.
- E. Prior to filling any structure with water, all cracks that may have developed shall be "vee'd" as shown and filled with sealant conforming to the requirements of Section 03290. This repair method shall be done on the water bearing face of members. Prior to backfilling, faces of members in contact with fill, which are not covered with a waterproofing membrane, shall also have cracks repaired.

3.13 PATCHING HOLES IN CONCRETE

A. **Patching Small Holes:**

- 1. Holes which are less than 12 inches in their least dimension and extend completely through concrete members, shall be filled as specified herein.
- 2. Small holes in members which are water-bearing or in contact with soil or other fill material, shall be filled with non-shrink grout. Where a face of the member is exposed to view, the non-shrink grout shall be held back 2 inches from the finished surface. The remaining 2 inches shall then be patched according to the Paragraph above.
- 3. Small holes through all other concrete members shall be filled with non-shrink grout, with exposed faces treated as above.

B. **Patching Large Holes:**

- 1. Holes which are larger than 12 inches in their least dimension, shall have a keyway chipped into the edge of the opening all around, unless a formed keyway exists. The holes shall then be filled with concrete as specified herein.
- 2. Holes which are larger than 24 inches in their least dimension and which do not have reinforcing steel extending from the existing concrete, shall have reinforcing steel set in grout in drilled holes. The reinforcing added shall match the reinforcing in the existing wall unless indicated otherwise.
- 3. Large holes in members which are water bearing or in contact with soil or other fill, shall have a bentonite type waterstop material placed around the perimeter of the hole as specified in the Section 03290 unless there is an existing waterstop in place.

3.14 CARE AND REPAIR OF CONCRETE

- A. The CONTRACTOR shall protect all concrete against injury or damage from excessive heat, lack of moisture, overstress, or any other cause until final acceptance by the OWNER. Particular care shall be taken to prevent the drying of concrete and to avoid roughening or otherwise damaging the surface. Any concrete found to be damaged, or which may have been originally defective, or which

becomes defective at any time prior to the final acceptance of the completed work, or which departs from the established line or grade, or which, for any other reason, does not conform to the requirements of the Contract Documents, shall be satisfactorily repaired or removed and replaced with acceptable concrete at the CONTRACTOR'S expense.

** END OF SECTION **